

Work Order ID 73848



Page 1

Friday, September 16, 2011 12:47:22 PM

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

[Signature]

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAA'S CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing inspection last completed 11.9.27 by B.A. ☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

27 11.9.27
B.A. 11/09/27

10

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

27 11.9.27
B.A. 11/09/27

10

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

27 11.9.27
B.A. 11/09/27

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73848

Friday, September 16, 2011 12:47:22 PM



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Item ID:	D2662-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, LH In 206					
Start Date:	9/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/28/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				10	0		
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				10	0		
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 9:00
FINISH TIME: 9:30
OVEN TEMPERATURE: 320°F

W118434

320°F

9:30

10x 0.00 11/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73848

Page 3

Friday, September 16, 2011 12:47:22 PM

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BR 11-10-3.

170

Identify as per dwg & Stock Location: 435

0.00



Packaging

Memo

0.00

Packaging

11/10/3 sl

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/5 JF
MF 11-10-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:47:20 PM

Page 1

Work Order ID: 73848

Parent Item: D2662-1

Parent Item Name: Saddle, LH In 206



Start Date: 9/16/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.06.22 Removed P/O for powder coat EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	49.0000	1	10			
Saddle Billet												11.9.27	

Location

Loc Qty

Loc Code

MAT040

49

64777 ✓

20

66965

1

69677

2

70976

10

72225

16

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				1	2	3	4	5	
A	0.100	0.140		.113	.113	0.111	0.110	0.110	
B	0.100	0.140		.138	.138	0.138	0.139	0.138	
C	1.125	1.145		1.139	1.139	1.138	1.138	1.137	
D	0.615	0.685		.688	.685	0.685	0.685	0.685	
E	0.240	0.260		.246	.246	0.246	0.246	0.247	
F	1.313	1.343		1.322	1.322	1.321	1.321	1.321	
G	0.210	0.230		.219	.219	0.220	0.218	0.218	
H	0.100	0.180		.135	.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.580	1.582	1.580	1.578	
K	0.235	0.240		.238	.238	0.238	0.238	0.238	
L	0.100	0.120		.110	.110	0.110	0.110	0.110	
M	0.990	1.010		.992	.992	0.997	0.997	0.997	
N	0.510	0.515		.514	.514	0.514	0.514	0.514	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.315	.315	0.315	0.315	0.315	
S	0.315	0.322		.317	.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.792	.792	0.797	0.797	0.797	
W	0.540	0.560		.550	.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.258	.258	0.258	0.258	0.258	
Z	0.912	0.932		.923	.923	0.927	0.923	0.922	
AA	0.490	0.510		.500	.500	0.501	0.502	0.500	
AB	0.178	0.198		.188	.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DS
Date:	11.9.27 / 11/09/27

Audited by:	aml
Date:	11/09/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					Date
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10 W	
A	0.100	0.140		0.110	0.111	0.112	0.113	0.112	
B	0.100	0.140		0.136	0.137	0.137	0.137	0.137	
C	1.125	1.145		1.137	1.139	1.139	1.140	1.139	
D	0.615	0.685		0.685	0.685	0.685	0.685	0.685	
E	0.240	0.260		0.247	0.247	0.246	0.246	0.246	
F	1.313	1.343		1.321	1.322	1.322	1.322	1.322	
G	0.210	0.230		0.218	0.220	0.220	0.221	0.220	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.581	1.580	1.580	1.581	1.580	
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238	
L	0.100	0.120		0.110	0.110	0.110	0.110	0.110	
M	0.990	1.010		0.992	0.992	0.992	0.992	0.992	
N	0.510	0.515		0.514	0.514	0.514	0.514	0.514	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.315	0.315	0.315	0.315	0.315	
S	0.315	0.322		0.317	0.317	0.317	0.317	0.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.797	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.258	0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.501	0.501	0.500	0.502	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	B.A.
Date:	11/09/27

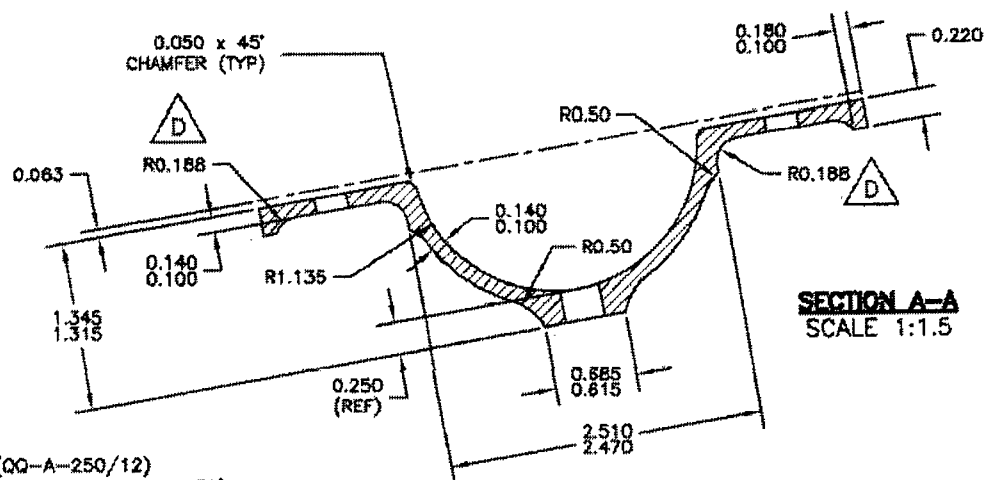
Audited by:	AmL
Date:	11/09/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



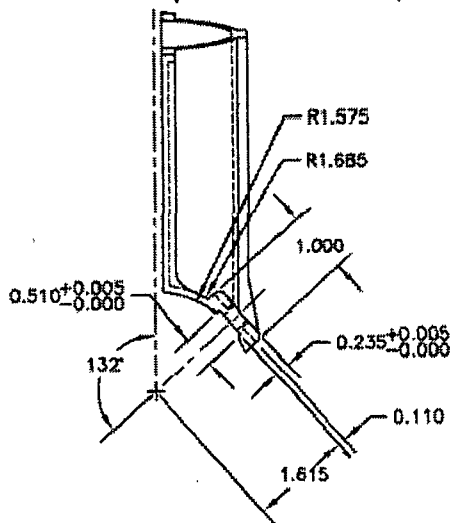
DESIGN #1	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #1	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED
07.02.02

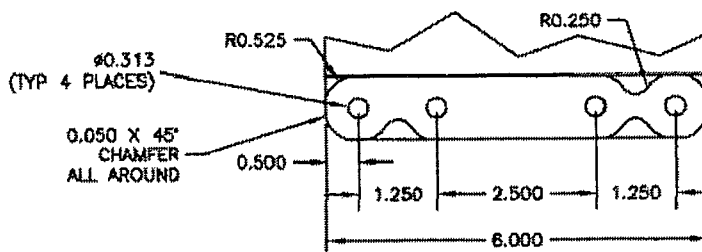
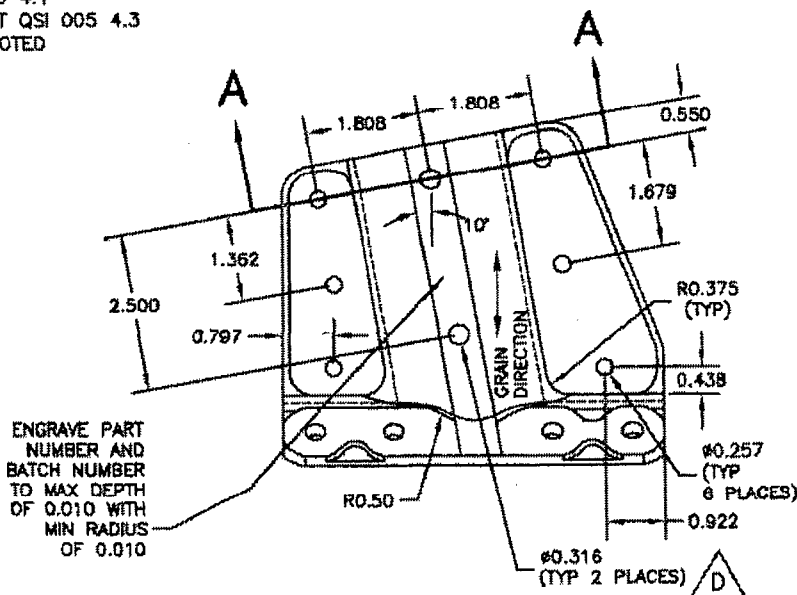


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



D2662-1 SADDLE INSIDE



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